

Work Order ID 60386

July 7, 2010 8:43:56 AM

Page 1

Item ID: D3773-3

Revision ID:

Item Name: Leg #

Start Date: 7/07/10 Start Qty: 10.00

Required Date: 7/13/10 Req'd Qty: 10.00

Reference: *7/10/07 02*

Approvals: Process Plan:

QC:

Date:

Date:

Accept

Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr Revision Nbr

D3773 Rev B

100



Doosan

Doosan Lathe

DOOSAN LATHE

0.00

Memo

0.00

1- Turn as per Folio FA763 Rev: & Dwg D3773 Rev: B 2-Deburr

SL 10/07/15 (10) φ

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SL 10/07/15

10 φ

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

H.A 10/07/17

10 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3773-3

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Start Qty: 10.00

Required Date: 7/13/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

130



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location 249

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10-7-19

sl

(100)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Accept

Cust Item ID:

Customer:

Setup Start

Stop



100720

MF 10-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60386

Parent Item: D3773-3

Parent Item Name: Leg



Start Date: 7/07/10

Required Date: 7/13/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 08-07-18 DD Verified By:cc

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR1.000W.065		Purchased	No			110	f	20.3725	1	10.52632			
304 RD Tube 1.00 x .065W													

Location

MAT

108922

110010

Loc Qty

20.37247368

10

10.3724737

Loc Code

8.14
2.46

JK 10/07/10

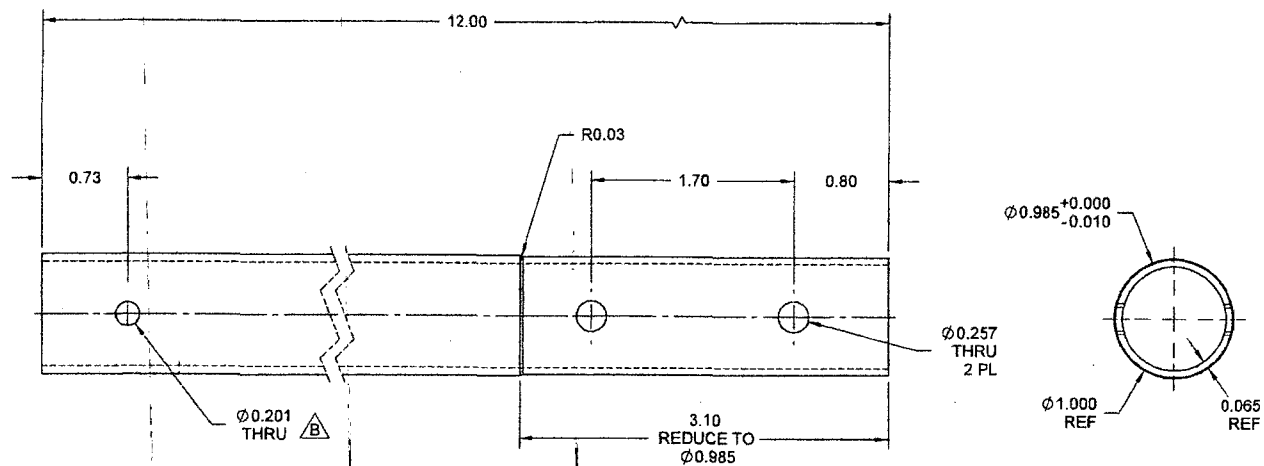
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



D3773-3 LEG

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3773	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		HEADREST ADAPTER	NTS
DATE	08.06.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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REL 08-07-10 MFD

w/o 60386